

Work Order ID 51567

August 26, 2009 10:52:13 AM



Page 1

Item ID: D2261 **BK**
 Revision ID: A1
 Item Name: Mirror Arm - Long S76

Accept



Setup Start



Stop



Start Date: 8/25/09 Start Qty: 3.00
 Required Date: 9/04/09 Req'd Qty: 3.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: **PL**
 QC:

Date: **09-8-26** Tooling:

Date:

Run Start



Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2261	Rev A1

100	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Punch tube 304/316 with 2B finish Form as per dwg D2261 Debur								

M.L. 09/08/27 **(3X)**

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=> 8/21/28 **(TS)** **φ**

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

=> 09/09/02 **(X3)** **φ**

M109091
 START TIME: **3:00pm** OVEN TEMPERATURE:
 FINISH TIME: **3:20pm** **320°F**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09093

3

140



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D2261

0.00

0.00

Mk 09/09/14/

3X

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2/802/15

X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

Identify as per dwg & Stock Location 228

0.00



Packaging

Memo

0.00

Packaging

9/9/16

③ SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/16 JF

RL 09-9-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

August 26, 2009 10:52:12 AM

Page 1

Work Order ID: 51567

Parent Item: D2261RevA1

Parent Item Name: Mirror Arm - Long S76


Comments:

Start Date: 8/25/09

Required Date: 9/04/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
A1449  Grommet		Purchased	No			100	Each	1,223.000	6.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1487 ✓

1223

1223

D2022-101

Manufactured

No

140

Each

0.0000

12.0000

Spacer

M304TR0.500W.035

Purchased

No

140

f

283.0441

9.4077

304 RD Tube .500 x .035W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

283.0441097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

224.4579

M-L 09/09/14

M1487

6x

*

M-L 09/09/14

M45885

12x

*

M112187

M-L 09/08/27

*

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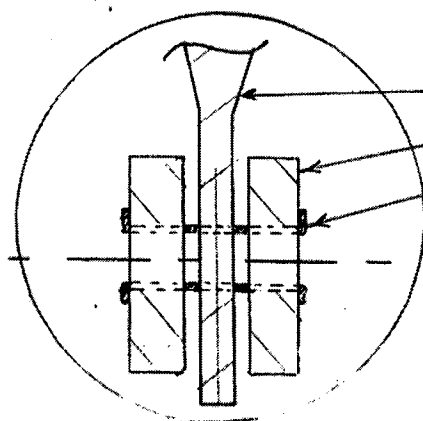
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DART



DRAWN <i>M. Cohen.</i>	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN	DRAWING NO. <i>D2261</i>	REV. <i>A</i>
<i>Aug 10/94</i>	TITLE <i>LONG TUBE</i>	
<i>A1</i>	<i>CP-0203.22</i>	ADD FINISH



D2261 LONG TUBE
D2012-101 SPACER (2x)
A1449 GROMMET

Should be D2022-101

SPACER CP 0301.06

STANDARD FLARE
BOTH ENDS

(PARALLEL TO PLANE OF BENDING)

ASSEMBLE PER DETAIL
AND SWAGE GROMMET
(2 LOCATIONS)

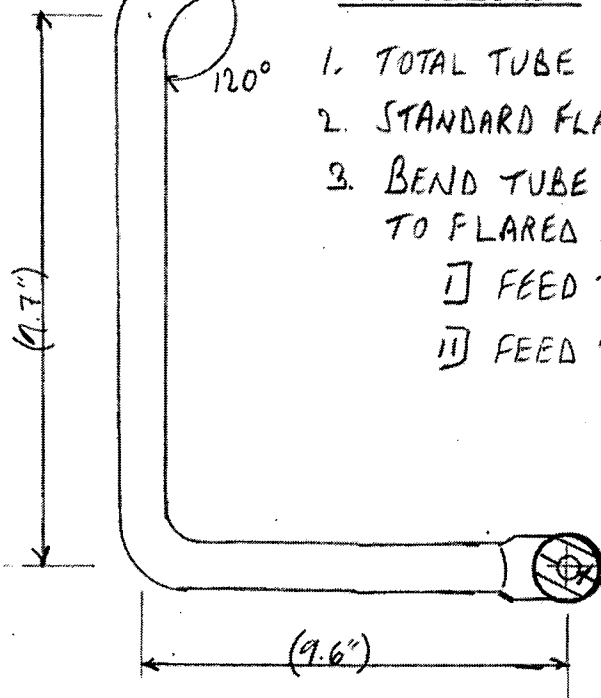
MATL: *304SS 1/2" OD x .035" WALL TUBE*
FINISH: *POWDER COAT BLACK SANDTEX (4.3.5.7)*
PER DART QSI 005 4.3 A1

PROCEDURE:

- 1. TOTAL TUBE LENGTH = 35.75"*
- 2. STANDARD FLARE BOTH ENDS*
- 3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.*

I FEED THRU 11", BEND 90°

II FEED THRU 19 3/4" (TOTAL), BEND 60°



.257" Dia Both Ends

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *51507*